

Date: Wednesday, 06/05/2009 8:51:33 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BEARPAW
<b>Job Number</b> : 47760	
<b>Estimate Number</b> : 11647	
<b>P.O. Number</b> :	<b>Part Number</b> : D2995
<b>This Issue</b> : 06/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2995 REV A1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A1
<b>Previous Run</b> : 43832	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 13/05/2009 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.05.08</u>	
<b>Comment</b> : Est A 01.03.07 New Issue EC Est Rev:B New Manufacturing Process 08-11-15 JLM Verified By:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MFG ENGINEERING	MFG ENGINEERING
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**Comment:** MFG ENGINEERING  
 Program Batch number

J.F.S 09/05/07

2.0	MUHMWB10	UHMW 1" Black
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**Comment:** Qty.: 2.7777 sf(s)/Unit Total : 16.6662 sf(s)  
 Pick:  
 Material: Black UHMW 1"  
 Batch 111354

HB9-5-8

3.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 CUT BLANK AS PER FILE D2995

HB9-5-8

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Inspect material for defects or damage prior to machining  
 Machine as per folio FA119  
 Deburr

6

88 09/05/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE.	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 06/05/2009 8:51:34 AM  
User: 7 Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW

Job Number: 47760

Part Number: D2995

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

88 09/05/13

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

09-05-13 (6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 477958

09/05/13 (6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/13

Job Completion



mf 09-05-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47760
<b>Description:</b> Bearpaw		<b>Part Number:</b> D2995
<b>Inspection Dwg:</b> D2995	<b>Rev:</b> A1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.625	+/-0.010	.621	✓			
0.250	+/-0.010	.245	✓			
R0.25	+/-0.030	.250	✓			
0.25 x 45°	+/-0.030 x 0.5°	.270	✓			
5.86	+/-0.030	5.866	✓			
0.950	+/-0.010	.945	✓			
0.433	+/-0.010	.430	✓			
19.00	+/-0.030	19.00	✓			
4.25	+/-0.030	4.254	✓			
3.63	+/-0.030	3.639	✓			
7.375	+/-0.010	7.380	✓			
11.625	+/-0.010	11.630	✓			
0.38	+/-0.030	.378	✓			
3.081	+/-0.010	3.080	✓			
17.73	+/-0.030	17.73	✓			
19.34	+/-0.030	19.34	✓			
Ø0.260	+0.006/-0.001	.260	✓			
<del>0.30</del>	<del>+/-0.030</del>	.311	✓			
Ø0.93	<del>+0.004/-0.001</del>	.922	✓			
	+/-0.030					
	+0.030					
	-0.000					

<b>Measured by:</b> SP	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/05/13	<b>Date:</b> 09-05-13	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.02	New Issue	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

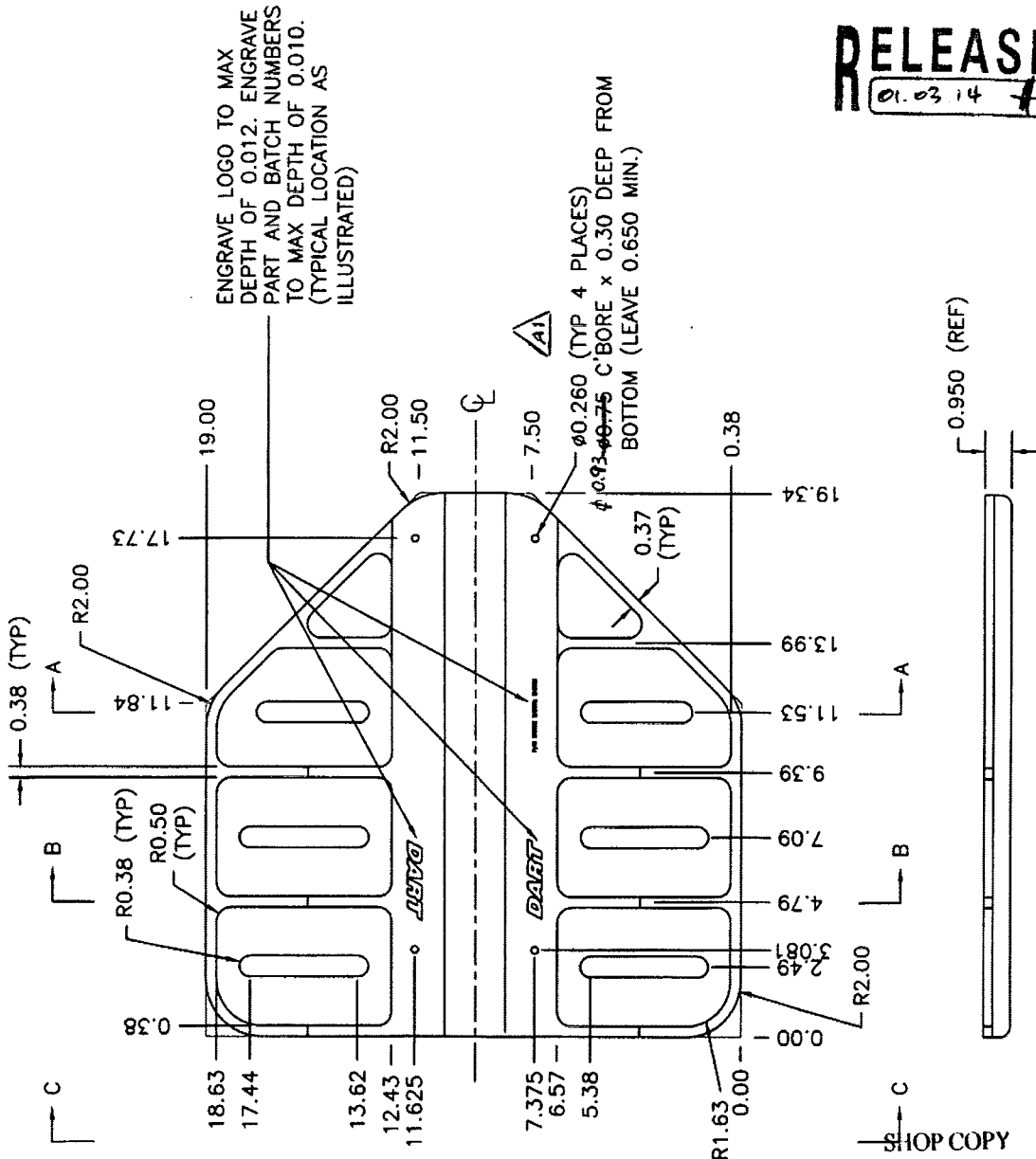
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2995	REV. A SHEET 1 OF 2
DATE 01.02.23		TITLE BEARPAW	SCALE 1:6
A	01.02.23	NEW ISSUE	
AI	<del>03.01.06</del>	<del>0.93 was 0.75</del>	

**RELEASED**  
01.03.14

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)  
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
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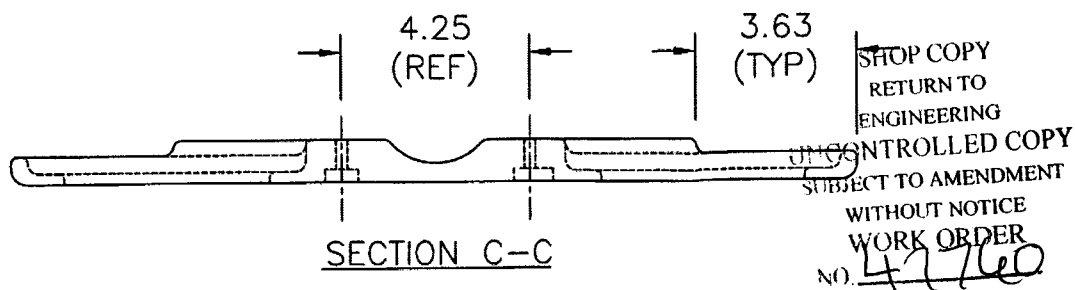
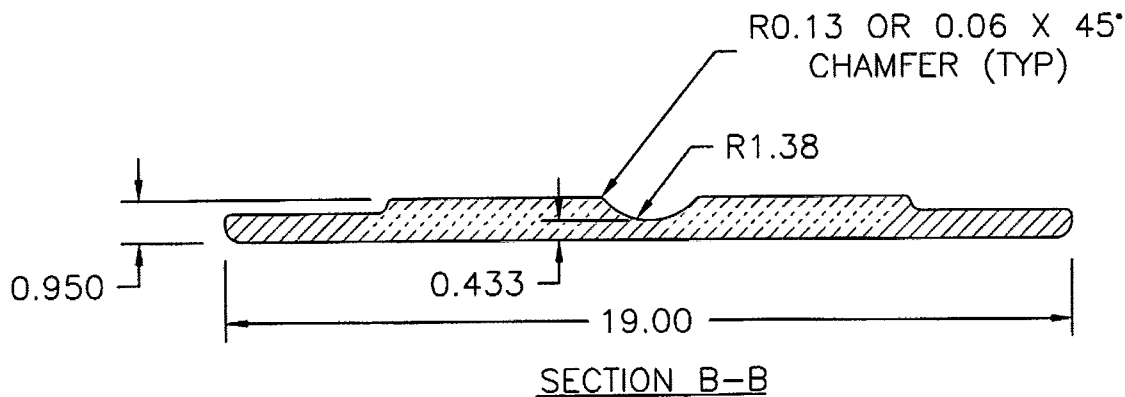
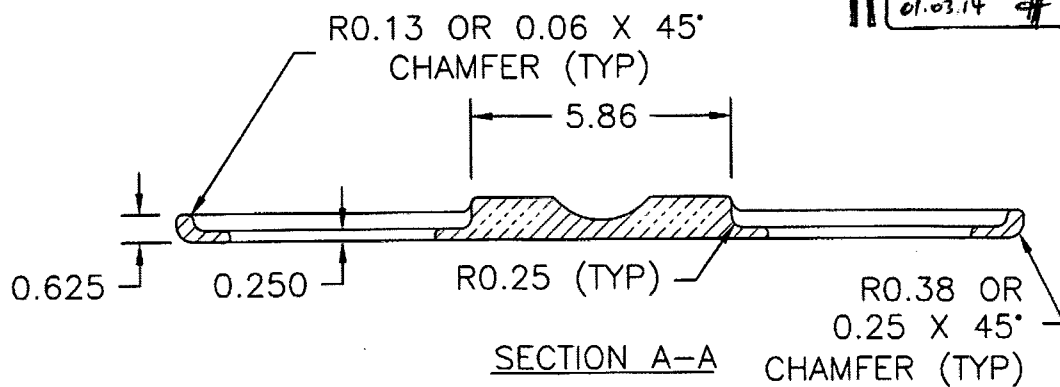
**NOTE:** Date & initial all entries





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D2995	REV. A SHEET 2 OF 2
DATE 01.02.23		TITLE BEARPAW	SCALE 1:4

RELEASED  
01.03.14 *A*



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